

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000533**Date Inspected:** 26-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Liang Zhang & Li Wen Sheng			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006			Component:	114	

Summary of Items Observed:

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the observations related the following;

Item-1 114 Skin-D, Upper section. In progress was the grinding and dressing of the completed cover pass welds at the ends of the stiffener plates.

Item-2 114 Corner section, B side, plate #P858, TA119 and P927. Filler pass welds being performed by welding operator (A) Wen Vanyan #066734 and (B) Cao Henjin #66420 both certified with Flux Core Arc Welding (FCAW) in the 3G position. Welding parameters recorded by this QA Inspector were, welder (A) #1 weld, Amps was 300, Volts 30.5 and a travel speed of 305 mm/min and welder (B) weld #2, Amps was 298, Volts 30 and the Travel Speed was 294 mm/min. The welding procedure used was WPS-B-T-2231-TC-U5-F. The ZPMC QA was Fu Yuhong, QC Zhang Qiao and CWI Xu Liang Zhang and Li Wen Sheng were present performing visual observations.

Item-3 114 Corner section, plate #P918 to A116, 345 material. Filler passes being added to weld #1 on A side by welder operator Jiang Zhou #040261. Welding parameters recorded by this QA Inspector were, Amps was 330, Volts 32 and the Travel Speed was 324 mm/min. The welding procedure used was WPS-B-T-2231-TC-U5-F. The attending CWI was Xu Le Feng.

Summary of Conversations:

There were no pertinent conversations pertaining to the project during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials

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for your project.

Inspected By: Smith,David

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer